

Date: Tuesday, 13/05/2008 11:08:47 AM  
User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DECK PLATE,FWD ,350 LITTER KIT		
Job Number	39239					
Estimate Number	11104					
P.O. Number	:			Part Number	: D2364	
This Issue	: 13/05/2008		S.O. No. :	Drawing Number	: D2364 REV.F	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: F	
Previous Run	: 38057			Material	:	
Written By	:			Due Date	: 05/06/2008	
Checked & Approved By	<u>JLD 08.5.13</u>			Qty:	6 Um: Each	
Comment	: EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		5.	
		Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s) HB 8-S-14 2024-T3 .063 Aluminum sheet (0.492)1K3 = 2.1 (M2024T3S063) 101022 x 1 .1 Batch: 105615 x 3 = 2.1	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2364 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> HB 8-5-14	(7)
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		HB 8-S-14	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		HB 8-S-14	
		Comment: SECOND CHECK	(8/05/15 X7)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1- counter sink holes as per dwg D2364	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 39239

Part Number: D2364

Job Number:



Seq. #: Machine Or Operation:

Description :

2- deburr if necessary

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/16 AP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EJ 19/03

08-05-16 X

8.0 POWDER COATING

POWDER COATING



M10S642

7X

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

7:20 am

START TIME:

OVEN TEMPERATURE:

320°F

FINISH TIME:

7:30 am

M.F.

08/05/21

9.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

Fd 08/05/21

7

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST186

A8 08/05/21 X

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/22 X

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39239
Description: Litter Deck Plate Kit (350)	Part Number:	D2364
Inspection Dwg: D2364 Rev: F		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.626	*			
Ø0.171	+0.005/-0.000	.173	*			
0.354	+/-0.010	.355	*			
11.242	+/-0.010	11.242	*			
3.031	+/-0.010	3.038	*			
1.903	+/-0.010	1.903	*			
1.128	+/-0.010	1.125	*			
0.354	+/-0.010	.355	*			
1.340	+/-0.005	1.354	*			
2.326	+/-0.010	2.330	*			
3.312	+/-0.010	3.316	*			
4.298	+/-0.010	4.301	*			
5.284	+/-0.010	5.286	*			
6.151	+/-0.010	6.155	*			
6.270	+/-0.010	6.272	*			
0.354	+/-0.010	.354	*			
3.031	+/-0.010	3.036	*			
Ø0.656	+0.005/-0.000	.656	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.607	*			
1.776	+/-0.010	1.776	*			
0.980	+/-0.010	.980	*			
4.487	+/-0.010	4.490	*			
7.192	+/-0.010	7.194	*			
7.597	+/-0.010	7.570	*			
7.942	+/-0.010	7.947	*			
Ø0.191	+0.005/-0.000	.192	*			
Ø0.197	+0.005/-0.000	.200	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.691	*			
0.250	+0.005/-0.000	.251	*			
3.141	+/-0.010	3.145	*			
0.171	+0.005/-0.000	.173	*			

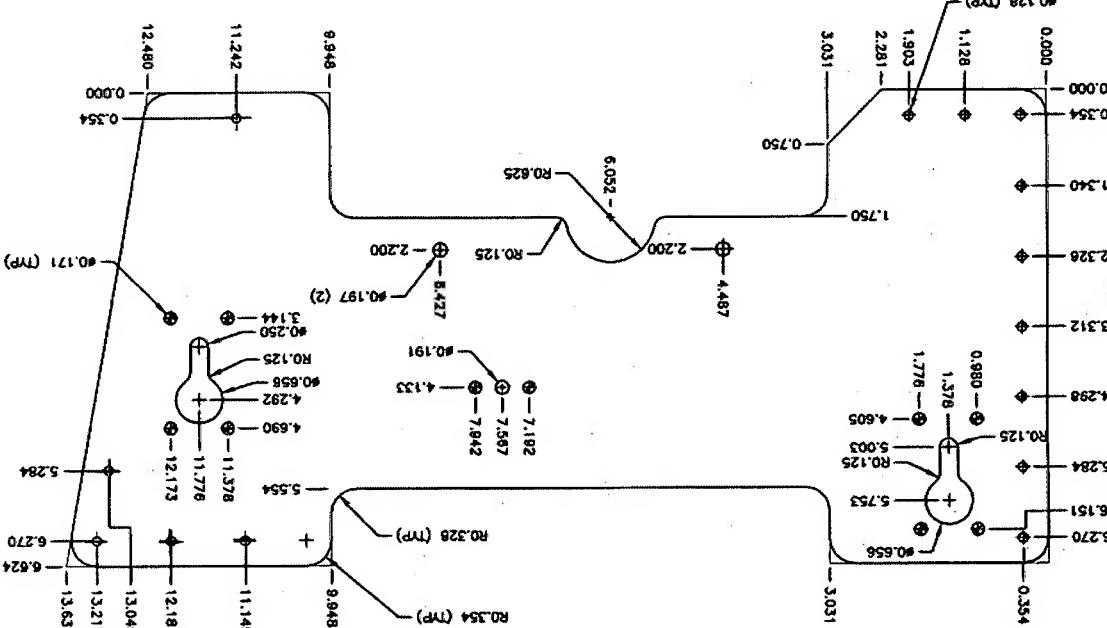
Measured by:	BB	Audited by:		Prototype Approval:	N/A
Date:	8-5-14	Date:	08/05/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM

DESIGN	DRAWN BY	KF	DART AEROSPACE LTD
CHECKED	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	D	D2364	DRAWING NO.
DATE	98.06.19	LITTER DECK PLATE, 350	TITLE
			SCALE 2:5

RELEASED  
98/06/22 KF

COUNTER SINK HOLES:  
♦ C'SINK Ø0.225 x 100. (UPDATED) From 9 to 14 Holes fit OS 99.03.01 to CORRECT CAD ERROR



MATERIAL: 2024-T3 (QO-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 022